



Dart Aerospace Ltd.  
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**RBW1805G01531-  
3G-1**

**Job Sheet 190578**



**Part No:** RBW1805G01531-3G-1

**Job Qty:** 1 pcs

**Part Name:** Mast Vibration Absorber Lift Base



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/11/19

**Job Tracking No:** SIOP

**Due Date:** 3/12/19

**Created By:** Dara Macdonald

**Type:** Stock

**Description:**

**Note:** DWG RBW1805G01531-3G REV 2 IPP Rev A 17.11.03 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation    | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Lead Time |
|-------|--------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------|
|       |              |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |
| 110   | SL-2500Y - 1 | 4 pcs | 3/12/19    | 3/12/19  | 0.50      | 1.00    | SL-2500Y - 1          |           |           |
| 120   | QC 2         | 4 pcs | 3/12/19    | 3/12/19  | 0.00      | 0.00    | QC 2 - 1              |           |           |
|       |              |       |            |          |           |         | QC 2 - 12             |           |           |
|       |              |       |            |          |           |         | QC 2 - 14             |           |           |
|       |              |       |            |          |           |         | QC 2 - 17             |           |           |
|       |              |       |            |          |           |         | QC 2 - 19             |           |           |
|       |              |       |            |          |           |         | QC 2 - 2              |           |           |
|       |              |       |            |          |           |         | QC 2 - 20             |           |           |
|       |              |       |            |          |           |         | QC 2 - 22             |           |           |
|       |              |       |            |          |           |         | QC 2 - 23             |           |           |
|       |              |       |            |          |           |         | QC 2 - 25             |           |           |
|       |              |       |            |          |           |         | QC 2 - 32             |           |           |
|       |              |       |            |          |           |         | QC 2 - 33             |           |           |
|       |              |       |            |          |           |         | QC 2 - 35             |           |           |
|       |              |       |            |          |           |         | QC 2 - 39             |           |           |
|       |              |       |            |          |           |         | QC 2 - 4              |           |           |
|       |              |       |            |          |           |         | QC 2 - 40             |           |           |
|       |              |       |            |          |           |         | QC 2 - 44             |           |           |
|       |              |       |            |          |           |         | QC 2 - 45             |           |           |
|       |              |       |            |          |           |         | QC 2 - 48             |           |           |
|       |              |       |            |          |           |         | QC 2 - 49             |           |           |
|       |              |       |            |          |           |         | QC 2 - 50             |           |           |
|       |              |       |            |          |           |         | QC 2 - 51             |           |           |
|       |              |       |            |          |           |         | QC 2 - 52             |           |           |
|       |              |       |            |          |           |         | QC 2 - 54             |           |           |
|       |              |       |            |          |           |         | QC 2 - 56             |           |           |
|       |              |       |            |          |           |         | QC 2 - 57             |           |           |
|       |              |       |            |          |           |         | QC 2 - 62             |           |           |
|       |              |       |            |          |           |         | QC 2 - 63             |           |           |
|       |              |       |            |          |           |         | QC 2 - 8              |           |           |

DAS  
Sign-off

9-89

DAS  
5  
9-89



**Container No:** S170962



**Part:** RBW1805G01531-3G-1

**Job No:** 190578

**Serial No/Batch:** S170962

**Revision:** 2

**Inspector:**

**Exp Date:**

**Instructions:**

Date: 04/09/19

|     |                             |       |         |           |                             |
|-----|-----------------------------|-------|---------|-----------|-----------------------------|
|     |                             |       |         | QC 2 - 66 |                             |
|     |                             |       |         | QC 2 - 64 |                             |
| 150 | Conventional Mill - 1 - B4B | 4 pcs | 3/12/19 | 0.00 1.00 | Conventional Mill - 1 - B4B |
|     |                             |       |         |           | Conventional Mill - 2 - B4B |
| 160 | QC 2                        | 4 pcs | 3/12/19 | 0.00 0.00 | QC 2 - 1                    |
|     |                             |       |         |           | QC 2 - 12                   |
|     |                             |       |         |           | QC 2 - 14                   |
|     |                             |       |         |           | QC 2 - 17                   |
|     |                             |       |         |           | QC 2 - 19                   |
|     |                             |       |         |           | QC 2 - 2                    |
|     |                             |       |         |           | QC 2 - 20                   |
|     |                             |       |         |           | QC 2 - 22                   |
|     |                             |       |         |           | QC 2 - 23                   |
|     |                             |       |         |           | QC 2 - 25                   |
|     |                             |       |         |           | QC 2 - 32                   |
|     |                             |       |         |           | QC 2 - 33                   |
|     |                             |       |         |           | QC 2 - 35                   |
|     |                             |       |         |           | QC 2 - 39                   |
|     |                             |       |         |           | QC 2 - 4                    |
|     |                             |       |         |           | QC 2 - 40                   |
|     |                             |       |         |           | QC 2 - 44                   |
|     |                             |       |         |           | QC 2 - 45                   |
|     |                             |       |         |           | QC 2 - 48                   |
|     |                             |       |         |           | QC 2 - 49                   |
|     |                             |       |         |           | QC 2 - 50                   |
|     |                             |       |         |           | QC 2 - 51                   |
|     |                             |       |         |           | QC 2 - 52                   |
|     |                             |       |         |           | QC 2 - 54                   |
|     |                             |       |         |           | QC 2 - 56                   |
|     |                             |       |         |           | QC 2 - 57                   |
|     |                             |       |         |           | QC 2 - 62                   |
|     |                             |       |         |           | QC 2 - 63                   |
|     |                             |       |         |           | QC 2 - 8                    |
|     |                             |       |         |           | QC 2 - 66                   |
|     |                             |       |         |           | QC 2 - 64                   |
| 170 | QC 8                        | 4 pcs | 3/12/19 | 0.00 0.00 | QC 8 - 12                   |
|     |                             |       |         |           | QC 8 - 14                   |
|     |                             |       |         |           | QC 8 - 17                   |
|     |                             |       |         |           | QC 8 - 20                   |
|     |                             |       |         |           | QC 8 - 25                   |
|     |                             |       |         |           | QC 8 - 3                    |
|     |                             |       |         |           | QC 8 - 32                   |
|     |                             |       |         |           | QC 8 - 33                   |
|     |                             |       |         |           | QC 8 - 35                   |
|     |                             |       |         |           | QC 8 - 39                   |
|     |                             |       |         |           | QC 8 - 4                    |
|     |                             |       |         |           | QC 8 - 44                   |
|     |                             |       |         |           | QC 8 - 45                   |
|     |                             |       |         |           | QC 8 - 49                   |
|     |                             |       |         |           | QC 8 - 58                   |
|     |                             |       |         |           | QC 8 - 8                    |
|     |                             |       |         |           | QC 8 - 9                    |
|     |                             |       |         |           | QC 8 - 68                   |
|     |                             |       |         |           | QC 8 - 67                   |
|     |                             |       |         |           | QC 8 - 1 (A)                |
|     |                             |       |         |           | QC 8 - 47                   |
| 180 | Packaging 3-1 - Stock - B4B | 4 pcs | 3/12/19 | 0.00 0.00 | Packaging 3 - 1 - B4B       |
|     |                             |       |         |           | Packaging 3 - 2 - B4B       |
|     |                             |       |         |           | Packaging 3 - 3 - B4B       |



|                |       |         |           |                        |             |
|----------------|-------|---------|-----------|------------------------|-------------|
|                |       |         |           | Packaging 3 - 4 - B4B  |             |
|                |       |         |           | Packaging 3 - 5 - B4B  |             |
|                |       |         |           | Packaging 3 - 6 - B4B  |             |
|                |       |         |           | Packaging 3 - 7 - B4B  |             |
|                |       |         |           | Packaging 3 - 8 - B4B  |             |
|                |       |         |           | Packaging 3 - 9 - B4B  |             |
|                |       |         |           | Packaging 3 - 10 - B4B |             |
|                |       |         |           | Packaging 3 - 11 - B4B |             |
|                |       |         |           | Packaging 3 - 12 - B4B | EL          |
|                |       |         |           | Packaging 3 - 13 - B4B |             |
|                |       |         |           | Packaging 3 - 14 - B4B |             |
|                |       |         |           | Packaging 3 - 15 - B4B |             |
|                |       |         |           | Packaging 3 - 16 - B4B |             |
|                |       |         |           | Packaging 3 - 17 - B4B |             |
|                |       |         |           | Packaging 3 - 18 - B4B |             |
|                |       |         |           | Packaging 3 - 19 - B4B |             |
|                |       |         |           | Packaging 3 - 20 - B4B |             |
|                |       |         |           | Packaging 3 - 21 - B4B |             |
|                |       |         |           | Packaging 3 - 22 - B4B |             |
|                |       |         |           | Packaging 3 - 23 - B4B |             |
|                |       |         |           | Packaging 3 - 24 - B4B |             |
|                |       |         |           | Packaging 3 - 25 - B4B |             |
|                |       |         |           | Packaging 3 - 26 - B4B |             |
|                |       |         |           | Packaging 3 - 27 - B4B |             |
|                |       |         |           | Packaging 3 - 28 - B4B |             |
|                |       |         |           | Packaging 3 - 29 - B4B |             |
|                |       |         |           | Packaging 3 - 30 - B4B |             |
|                |       |         |           | Packaging 3 - 31 - B4B |             |
|                |       |         |           | Packaging 3 - 32 - B4B |             |
|                |       |         |           | Packaging 3 - 33 - B4B |             |
|                |       |         |           | Packaging 3 - 34 - B4B |             |
|                |       |         |           | Packaging 3 - 35 - B4B |             |
|                |       |         |           | Packaging 3 - 36 - B4B |             |
| 190 QC 21 - SA | 4 pcs | 3/12/19 | 0.00 0.00 | QC 21 - SA - 21        | DAS 21 9-89 |
|                |       |         |           | QC 21 - SA - 70        |             |
|                |       |         |           | QC 21 - SA - 53        |             |

APR 12 2019

Part Op 110 - (MORI SL2500Y LATHE) - Machine as per DWG. RBW1805G01531-3G-1 and Folio FB927 Program Serial #

Descriptions: \_\_\_\_\_ - Deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (Manufacture as per dwg) -Mill side notches

160 - (QC2- Inspect parts off machine FAI/FAIB) -Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

170 - (QC8- Inspect parts - second check)

180 - (Identify as per dwg & Stock Location: \_\_\_\_\_)

190 - (QC21- Final Inspection - Work Order Release)

| Job BOM     |                    |                  |                  |           |
|-------------|--------------------|------------------|------------------|-----------|
| Part / Item | Component Name     | Quantity         | Operation        | Container |
| M304R2.000  | 304 Round Bar 2.00 | .6000 ft (15 ea) | 110-SL-2500Y - 1 | H128005   |

144

34 1/8

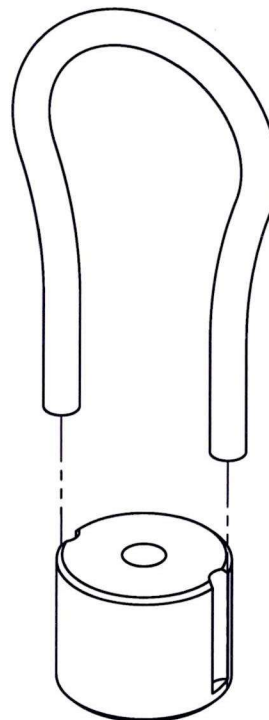
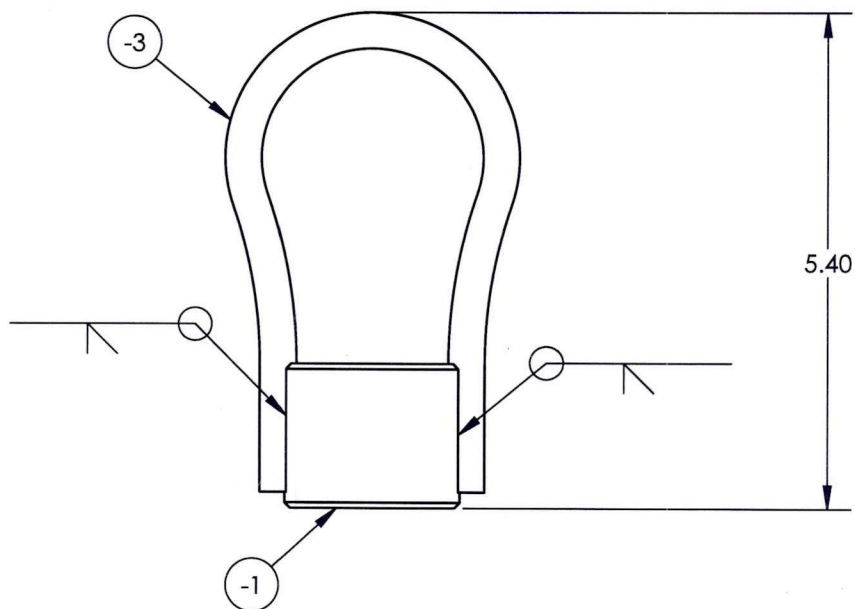
20 1/4

| Job Allocations  |                |          |           |           |
|------------------|----------------|----------|-----------|-----------|
| Operation        | Component Part | Required | Inventory | Allocated |
| 110-SL-2500Y - 1 | M304R2.000     | 1        | 6         | 0         |

| Part Specifications                |  |
|------------------------------------|--|
| Specifications could not be found. |  |

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| REVISIONS |         |                                |          |         |          |
|-----------|---------|--------------------------------|----------|---------|----------|
| REV       | ECR     | DESCRIPTION                    | DATE     | INITIAL | APPROVED |
| 2         | 15-0284 | -1 CH'D DIM WAS Ø.477 IS Ø.48. | 9/1/2015 | RJC     | JAG      |



**NOTE:**

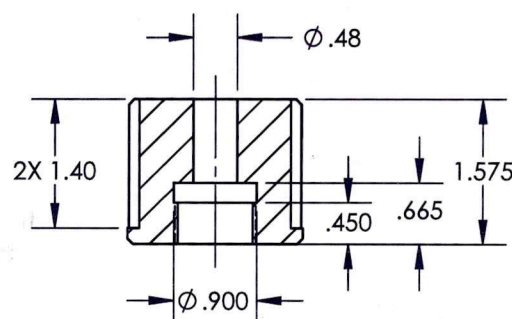
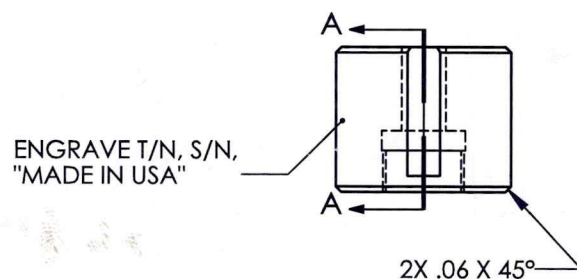
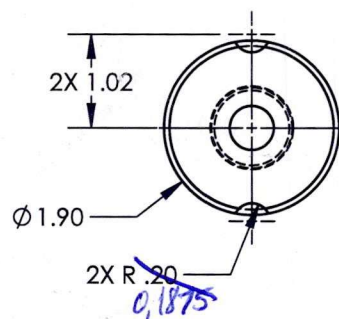
1. REF. AUGUSTA T/N: 3G1805G01531.
2. ALSO PART OF KIT RBW1805G01431-3G, REF. AUGUSTA T/N: 3G1805G01431.

|                                                                                                                                               |                                                                                   |
|-----------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                                     |                                                                                   |
| TITLE<br><b>MVA LIFTING TOOL</b>                                                                                                              |                                                                                   |
| DWG NO.<br><b>RBW1805G01531-3G</b>                                                                                                            | REV<br><b>2</b>                                                                   |
| MAT'L<br><b>UNLESS OTHERWISE SPECIFIED<br/>DIMENSIONS ARE IN INCHES<br/>.XXX ± .005 FRACTIONS ± 1/8<br/>.XX ± .01 ANGLES ± 5°<br/>.X ± .1</b> | DRAWN BY: <b>SMITH</b><br>APPROVED: <i>D Weil</i><br>HEAT TREAT<br>FINISH<br>SPEC |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                  | USED ON MODEL<br><b>AW139</b>                                                     |
| SCALE <b>1:2</b>                                                                                                                              | DATE <b>4/29/2013</b> SHEET <b>1 OF 3</b>                                         |

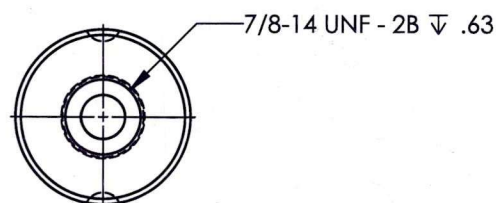
| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description     | Material | B/O INFORMATION OR SPECIFICATIONS | PG. |
|----------|----------|-----|--------|----------|-----------------|----------|-----------------------------------|-----|
|          |          |     | -1     | 1        | MVA LIFT BASE   | S.S.     |                                   | 2   |
|          |          |     | -3     | 1        | MVA LIFT HANDLE | S.S.     |                                   | 3   |

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| REVISIONS |         |                                |          |         |          |
|-----------|---------|--------------------------------|----------|---------|----------|
| REV       | ECR     | DESCRIPTION                    | DATE     | INITIAL | APPROVED |
| 2         | 15-0284 | -1 CH'D DIM WAS Ø.477 IS Ø.48. | 9/1/2015 | RJC     | JAG      |



SECTION A-A



(-1)

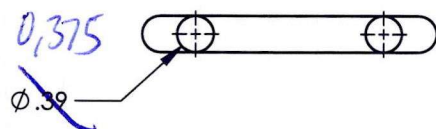
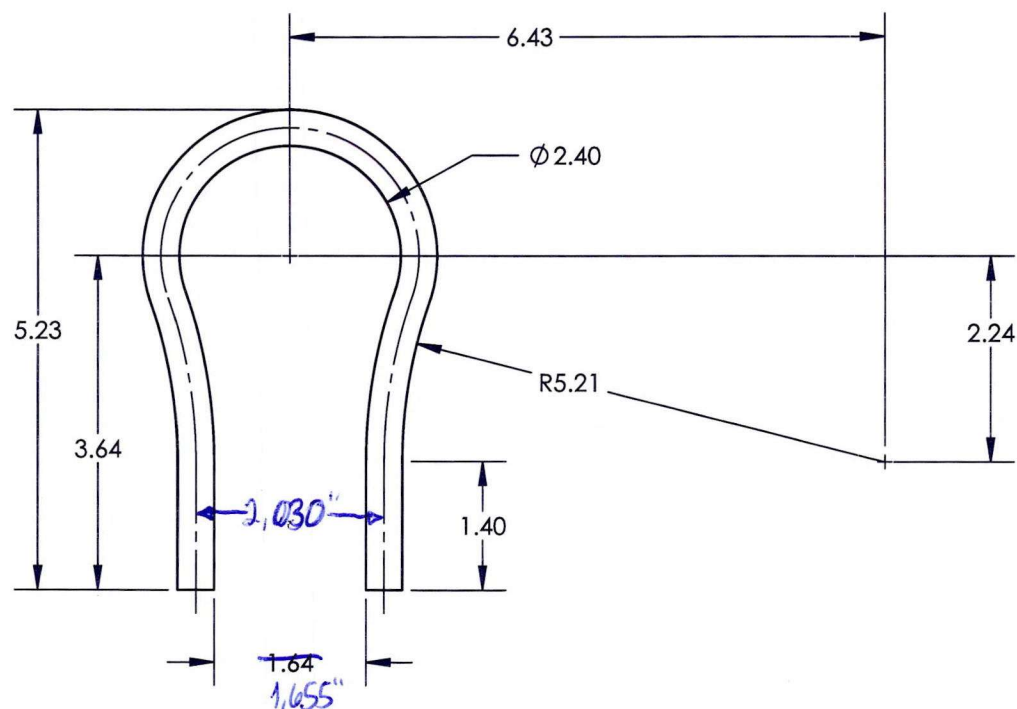
MVA LIFT BASE

|                                                                                                                                         |                                                                                                      |
|-----------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                               |                                                                                                      |
| TITLE<br>MVA LIFTING TOOL                                                                                                               |                                                                                                      |
| DWG NO.<br>RBW1805G01531-3G-1                                                                                                           | REV<br>2                                                                                             |
| MAT'L S.S.<br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ± 5°<br>.X ± .1 | DRAWN BY: SMITH<br>APPROVED: <i>D Weil</i><br>HEAT TREAT<br>FINISH<br>SPEC<br>USED ON MODEL<br>AW139 |
| 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                               |                                                                                                      |
| SCALE<br>1:2                                                                                                                            | DATE<br>4/29/2013                                                                                    |
| SHEET 2 OF 3                                                                                                                            |                                                                                                      |



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| REVISIONS |     |             |                       |
|-----------|-----|-------------|-----------------------|
| REV       | ECR | DESCRIPTION | DATE INITIAL APPROVED |



③

MVA LIFT HANDLE

|                                                        |                        |
|--------------------------------------------------------|------------------------|
| <b>DART<br/>AEROSPACE</b>                              |                        |
| TITLE<br>MVA LIFTING TOOL                              |                        |
| DWG NO.<br>RBW1805G01531-3G-3                          | REV<br>2               |
| MAT'L S.S.                                             | DRAWN BY: SMITH        |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES | APPROVED <i>D Weil</i> |
| .XXX ± .010                                            | HEAT                   |
| .XX ± .03                                              | TREAT                  |
| .X ± .1                                                | FINISH                 |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R        | SPEC                   |
| 2. DIMENSIONAL LIMITS APPLY AFTER<br>PLATING           | USED ON MODEL          |
|                                                        | AW139                  |
| SCALE 1:2                                              | DATE 4/29/2013         |
| SHEET 3 OF 3                                           |                        |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



190578  
RBW 1805601531-36-1

## Page 1 of 1

8/19/41

4/9/2019

Date:

|                   |                 |
|-------------------|-----------------|
| <b>Revised by</b> | <b>Approved</b> |
| KJ                |                 |